

Work Order ID 115746

April-04-14 10:20:43 AM

115746

Page 1

Item ID: D3500-1

D 3500 - 1

B 115746

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle

Start Date: 4/04/14

Start Qty: 40.00

40

Cust Item ID:

Required Date: 4/04/14

Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 14-04-08

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
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D3500	C	
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100		0.00
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100

HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 115746 Double check by ML 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets3-Machine Step No 3 per Folio FA641 and inspect p

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

40 φ JFC 2014-05-17

DAS 44 14/05/20
SVD 9-89

40 φ JFC 2014-05-17

DAS 44 14/05/20
9-89

40 φ JFC 2014-05-17

DAS 14
9-89
14/05/20

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order:	DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part No.	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>					
NCR No.	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>					
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>					
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>						
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design										
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										
FAULT CATEGORY										
Landing Gear	General									
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>						Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>						Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>						Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>						Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>						Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>						Positioned Wrong <input type="checkbox"/>	
	Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>						Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>
	Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>							
	Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>							
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
	Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							

Work Order ID 115746***115746***

Page 2

April-04-14 10:20:43 AM

Item ID: D3500-1

Revision ID:

Item Name: Saddle

Start Date: 4/04/14

Start Qty: 40.00 ***40***

Required Date: 4/04/14

Req'd Qty: 40.00 ***40***

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NS1

QC:

Date:

SPC (Y/N):

Date:

Stop

NS2

Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Hand Finishing

40 784527

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

140

Powdercoat

Powder Coating

M 128959.

Memo

0.00

START TIME:

2:00

OVEN TEMPERATURE:

FINISH TIME:

2:00

40 8 14-5-27

DAS 34 889

150

QC3- Inspect Part Finish

0.00

DAS
27
-89***150***

QC

Quality Control

0.00

M 15108

40
Count

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>		Water Jet <input type="checkbox"/>		Engineering <input type="checkbox"/>			
NCR No. _____		Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>		Prod. Eng. Coor. <input type="checkbox"/>		Quality <input type="checkbox"/>			
		Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>		Rec/Store/Packaging <input type="checkbox"/>		Other <input type="checkbox"/>			
		Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>		Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function							
				<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence							
				<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge							
				<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled							
				<input type="checkbox"/> Other							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
	Bending <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
	Centre Not Concentric <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
	Cracks <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
	Cuffs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
	Crushing <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
	Heat Treat <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	
	Inspection Strip in Tube <input type="checkbox"/>	Misread <input type="checkbox"/>		
	Marks/Chatter <input type="checkbox"/>	Off-set <input type="checkbox"/>		
	Turning Sequence <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
	Wave/Twist in Tube <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		

Picklist Print

April-04-14 10:20:42 AM

Page 1

Work Order ID: 115746

115746
D3500-1

Parent Item: D3500-1

Parent Item Name: Saddle

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	94.0000	1	40			**

D6102-013

Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	52	
104299	22	
105041	20	
105554	10	
MAT046	42	
109518	10	
110225	12	
110994	8	
111533	12	

B117029

40

LSP
14/03/17

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>							
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material															
Operator															
Offset/Setup															
Process															
Supplier															
Training															
Transport															
Unapproved															
FAULT CATEGORY															
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function		<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence						<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	

DART AEROSPACE LTD				Work Order:	115746
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		0.485	0.485	0.485	0.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.495	0.498	0.499	0.499		
H	0.515	0.535		R0525	0.525	0.525	0.525		
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.587	1.581	1.5815		
J	0.240	0.260		0.248	0.245	0.250	0.249		
K	0.490	0.510		0.498	0.498	0.497	0.497		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.317	0.316	0.316	0.316		
N	0.256	0.262		0.260	0.258	0.258	0.258		
O	6.500	6.520		6.510	6.508	6.5085	6.508		
P	5.990	6.010		5.999	6.003	6.0015	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.547	0.545	0.545	0.545		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		R0250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.1317	1.1356	1.1305	1.1315		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.625	0.625	0.625	0.625		
AD	0.240	0.260		0.257	0.257	0.260	0.257		
AE	1.810	1.830		1.822	1.822	1.822	1.8215		
AF	0.240	0.260		0.251	0.258	0.254	0.253		
AG	0.140	0.160		0.155	0.157	0.155	0.153		
AH	0.140	0.160		0.158	0.157	0.157	0.156		
AI	0.140	0.160		0.155	0.150	0.154	0.155		

Accept/Reject

DAS

Measured by: JFC
Date: 26/05/17

Audited by:
Date: 14
9-09

14
9-09
14/05/26

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	JK

DART AEROSPACE LTD				Work Order: 115746					
Description: Saddle				Part Number: D3500-1					
Inspection Dwg: D3500 Rev: C				Page 1 of 1					
Dim	Min	Max	Go/No Go Gauge	15	26	37	48	By	Date
A	0.483	0.490		0.485	0.485	0.485	0.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.499	0.499	0.500	0.499		
H	0.515	0.535		0.525	0.525	0.527	0.525		
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.589	1.584	1.583		
J	0.240	0.260		0.245	0.241	0.241	0.250		
K	0.490	0.510		0.499	0.497	0.498	0.507		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.507	6.508	6.509	6.508		
P	5.990	6.010		6.005	6.006	6.006	6.0010		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.549	0.549	0.549	0.549		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.134	1.135	1.134	1.133		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.625	0.625	0.625	0.625		
AD	0.240	0.260		0.254	0.255	0.254	0.257		
AE	1.810	1.830		1.821	1.821	1.821	1.821		
AF	0.240	0.260		0.251	0.251	0.251	0.251		
AG	0.140	0.160		0.155	0.155	0.155	0.155		
AH	0.140	0.160		0.153	0.155	0.155	0.155		
AI	0.140	0.160		0.152	0.152	0.153	0.153		
Accept/Reject				DAS					

14

Measured by: JFL	Audited by: 9-89
Date: 2014-05-18	Date: 14/05/26

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD				Work Order: 115746					
Description: Saddle				Part Number: D3500-1					
Inspection Dwg: D3500 Rev: C				Page 1 of 1					
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	210	311	412	By	Date
A	0.483	0.490		0.485	0.485	0.485	0.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.498	0.498	0.498	0.498		
H	0.515	0.535		0.525	0.525	0.525	0.525		
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.584	1.584	1.584	1.584		
J	0.240	0.260		0.256	0.247	0.247	0.247		
K	0.490	0.510		0.498	0.498	0.498	0.498		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.507	6.508	6.508	6.508		
P	5.990	6.010		6.000	6.005	6.005	6.005		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.549	0.549	0.549	0.549		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.133	1.132	1.132	1.133		
AB	R.490	R.510		0.502	0.502	0.502	0.502		
AC	0.615	0.635		0.625	0.625	0.625	0.625		
AD	0.240	0.260		0.251	0.255	0.255	0.255		
AE	1.810	1.830		1.826	1.821	1.821	1.821		
AF	0.240	0.260		0.152	0.154	0.154	0.154		
AG	0.140	0.160		0.142	0.150	0.150	0.150		
AH	0.140	0.160		0.145	0.155	0.155	0.155		
AI	0.140	0.160		0.145	0.153	0.152	0.152		
Accept/Reject				DAS					

Measured by:	JKC
Date:	2014-05-19

Audited by:	14
Date:	9-89 14/05/26

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	JK

DART AEROSPACE LTD				Work Order:	115746
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	214	315	416	By	Date
A	0.483	0.490		0.485	0.485	0.485	0.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.498	0.498	0.498	0.499		
H	0.515	0.535		0.525	0.525	0.525	0.525		
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.5893	1.5865	1.5875		
J	0.240	0.260		0.245	0.245	0.245	0.250		
K	0.490	0.510		0.498	0.498	0.498	0.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.508	6.508	6.508	6.509		
P	5.990	6.010		6.006	6.006	6.006	6.007		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.548	0.548	0.548	0.555		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.1323	1.1358	1.131	1.133		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.625	0.625	0.625	0.628		
AD	0.240	0.260		0.250	0.250	0.250	0.250		
AE	1.810	1.830		1.820	1.820	1.820	1.822		
AF	0.240	0.260		0.251	0.251	0.251	0.252		
AG	0.140	0.160		0.155	0.155	0.155	0.158		
AH	0.140	0.160		0.156	0.156	0.156	0.156		
AI	0.140	0.160		0.155	0.155	0.155	0.152		

Accept/Reject

DAS

Measured by:	JFE	Audited by:	14
Date:	2014-05-19	Date:	9-09-14

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	JK

DART AEROSPACE LTD				Work Order: 115746					
Description: Saddle				Part Number: D3500-1					
Inspection Dwg: D3500 Rev: C				Page 1 of 1					
Recorded Actual Dimensions									
Dim	Min	Max	Go/No Go Gauge	17	218	219	220	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		.498	.500	.500	.499		
H	.515	.535		.525	.525	.525	.525		
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5885	1.587	1.587	1.586		
J	0.240	0.260		.249	.249	.249	.250		
K	0.490	0.510		.499	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	.316	.316	.316		
N	0.256	0.262		0.258	.258	.258	.258		
O	6.500	6.520		6.509	6.509	6.509	6.510		
P	5.990	6.010		6.004	6.005	6.003	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.554	.552	.554	.552		
V	0.793	0.803		0.798	.798	.798	.798		
W	R.240	R.260		0.250	.250	.250	.250		
X	0.040	0.060		0.050	.050	.050	.050		
Y	0.100	0.120		0.110	.110	.110	.110		
AA	R1.125	R1.145		1.134	1.133	1.133	1.132		
AB	R.490	R.510		0.500	.500	.500	.500		
AC	0.615	0.635		0.625	.635	.635	.635		
AD	0.240	0.260		.260	.259	.260	.259		
AE	1.810	1.830		1.823	1.826	1.821	1.820		
AF	0.240	0.260		.254	.251	.253	.251		
AG	0.140	0.160		.154	.153	.154	.153		
AH	0.140	0.160		.155	.155	.155	.155		
AI	0.140	0.160		.152	.152	.153	.153		
Accept/Reject								DAS	

Measured by: FK	Audited by: 14
Date: 14/05/20	Date: 14/05/20

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	JK

DART AEROSPACE LTD				Work Order:	115746
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.499	.498	.499	.498		
H	.515	.535		.525	.525	.525	.525		
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5865	1.5855	1.586	1.586		
J	0.240	0.260		.250	.250	.250	.249		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.509	6.510	6.510	6.508		
P	5.990	6.010		6.003	6.004	6.004	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.554	.554	.554	.554		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.1325	1.1315	1.132	1.132		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.260	.258	.259	.259		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.252	.251	.252	.251		
AG	0.140	0.160		.153	.153	.152	.152		
AH	0.140	0.160		.152	.152	.151	.150		
AI	0.140	0.160		.150	.153	.153	.149		
Accept/Reject				DAS				14	

Measured by:	F.K.	Audited by:	9-69
Date:	14/05/20	Date:	14/05/26

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD				Work Order:	115746
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	25	26	27	28	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.498	.498	.498	.498		
H	.515	.535		.525	.525	.525	.525		
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5855	1.586	1.586	1.5865		
J	0.240	0.260		.249	.250	.251	.251		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.6620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.259	.258	.258		
O	6.500	6.520		6.509	6.508	6.508	6.509		
P	5.990	6.010		6.003	6.004	6.003	6.003		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.554	.554	.555	.555		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.1315	1.132	1.132	1.1325		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.260	.259	.259	.259		
AE	1.810	1.830		1.820	1.820	1.819	1.820		
AF	0.240	0.260		.252	.252	.251	.252		
AG	0.140	0.160		.152	.153	.152	.153		
AH	0.140	0.160		.151	.151	.151	.152		
AI	0.140	0.160		.150	.150	.150	.149		

Accept/Reject

DAS

14

Measured by: FK
 Date: 14/05/20

Audited by: 9-99
 Date: 14/05/20

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	JK

DART AEROSPACE LTD				Work Order: 115746					
Description: Saddle				Part Number: D3500-1					
Inspection Dwg: D3500 Rev: C				Page 1 of 1					
Dim	Min	Max	Go/No Go Gauge	29	30	31	32	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.498	.499	.498	.498		
H	.515	.535		.525	.525	.525	.525		
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.587	1.586	1.587		
J	0.240	0.260		.251	.250	.250	.250		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.509	6.507	6.510	6.508		
P	5.990	6.010		6.005	6.005	6.003	6.005		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.554	.555	.555	.554		
V	0.793	0.803		.798	.798	.799	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.133	1.133	1.132	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.258	.258	.258	.258		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.252	.252	.251	.252		
AG	0.140	0.160		.153	.154	.153	.154		
AH	0.140	0.160		.150	.150	.150	.151		
AI	0.140	0.160		.149	.149	.151	.150		
								DAS	
								14	
								DAS	
Accept/Reject				14				9.89	

Measured by: FK
Date: 14/05/21

Audited by: 14
Date: 14/05/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	JK

DART AEROSPACE LTD				Work Order:	115746
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	4	5	6	7	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.497	.498	.498	.498		
H	.515	.535		.525	.525	.525	.525		
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.5875	1.587	1.5865	1.5853		
J	0.240	0.260		.251	.251	.250	.250		
K	0.490	0.510		.500	.500	.500	.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.507	6.508	6.510	6.509		
P	5.990	6.010		6.005	6.004	6.004	6.004		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.555	.555	.555	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.133	1.133	1.1325	1.1343		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.257	.258	.257	.254		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.252	.252	.251	.252		
AG	0.140	0.160		.153	.154	.153	.155		
AH	0.140	0.160		.151	.150	.150	.155		
AI	0.140	0.160		.149	.149	.149	.156		

Accept/Reject

DAS

Measured by:	Fk	JPC	Audited by:	14
Date:	14/05/21	20140522	Date:	08/05/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD				Work Order: 115746					
Description: Saddle				Part Number: D3500-1					
Inspection Dwg: D3500 Rev: C				Page 1 of 1					
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		0.486	0.486	0.486	0.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.498	0.498	0.498	0.498		
H	0.515	0.535		0.525	0.525	0.525	0.525		
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.586	1.5875	1.5877		
J	0.240	0.260		0.250	0.250	0.248	0.250		
K	0.490	0.510		0.498	0.498	0.498	0.498		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.316	0.316	0.316	0.316		
N	0.256	0.262		0.258	0.258	0.258	0.258		
O	6.500	6.520		6.508	6.508	6.508	6.508		
P	5.990	6.010		6.006	6.006	6.006	6.006		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.280	2.280	2.250	2.250		
T	1.120	1.130		1.125	1.128	1.128	1.125		
U	0.540	0.560		0.549	0.549	0.549	0.549		
V	0.793	0.803		0.798	0.798	0.798	0.798		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.050	0.050	0.050	0.050		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
							0		
AA	R1.125	R1.145		1.1316	1.1326	1.1348	1.1337		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.625	0.625	0.625	0.625		
AD	0.240	0.260		0.252	0.252	0.253	0.251		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.255	0.255	0.255	0.255		
AG	0.140	0.160		0.153	0.154	0.155	0.154		
AH	0.140	0.160		0.155	0.155	0.157	0.155		
AI	0.140	0.160		0.153	0.153	0.154	0.153		

Accept/Reject

DAS

Measured by: Jfc	Audited by:	14
Date: 2014-05-22	Date:	9-09 14/05/2014

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	11

SHOP COPY

RETURN TO

ESTATE PLANNING

UNCONTROLLABLE

SUBJECT TO AMENDMENT

WITHOUT MARGIN

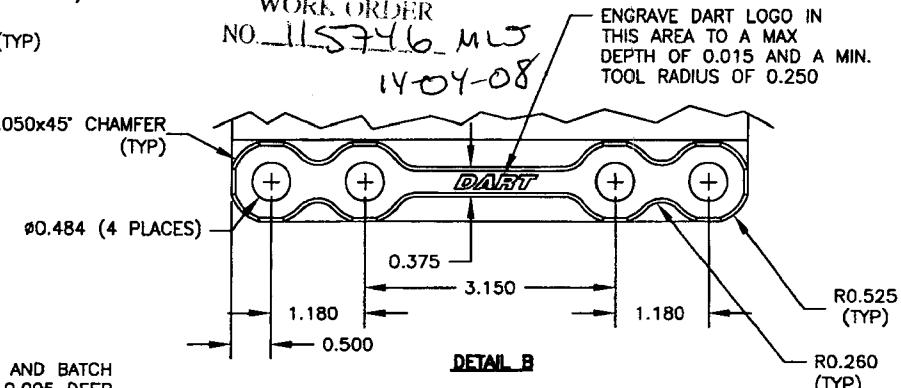
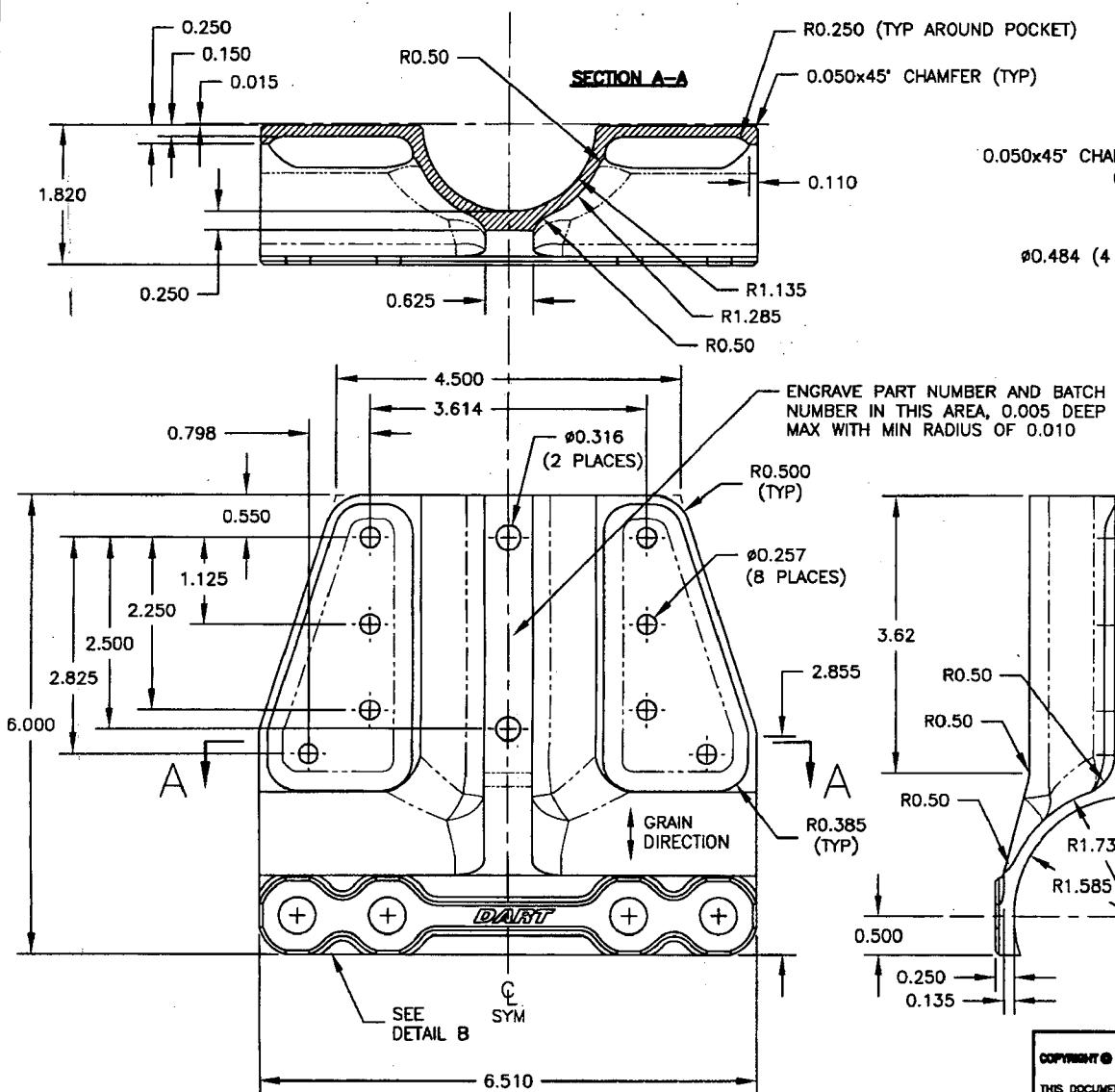
WORK ORDER
NO. 115244

NO. 1153716

14-04-01

14-04-0

- ENGRAVE DART LOGO IN
THIS AREA TO A MAX
DEPTH OF 0.015 AND A MIN.
TOOL RADIUS OF 0.250



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11)
(MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.08.15 ✓

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE LTD. MISSISSAUGA, ONTARIO, CANADA
99	PH	DART
CHECKED	APPROVED	DRAWING NO. REV. C
4	4	D3500
DATE	TITLE SCALE	
06.06.30	SADDLE 2-3	

11. *What is the best way to increase the number of people who use a particular service?*

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